

Message Text

CONFIDENTIAL

PAGE 01 PARIS 21874 281537Z

ACTION EB-08

INFO OCT-01 EUR-12 ISO-00 DODE-00 NSAE-00 USIA-06

TRSE-00 ERDA-05 CIAE-00 COME-00 ACDA-07 /039 W

-----116369 290129Z /63

R 281505Z JUL 77

FM AMEMBASSY PARIS

TO SECSTATE WASHDC 6318

C O N F I D E N T I A L PARIS 21874

USOECD

EXCON

E.O. 11652: XGDS1

TAGS: ESTC COCOM IT UR

SUBJ: ITALIAN MACHINE TOOLS TO USSR - IL 1091

REF: A) COCOM DOC (77) 459, B) STATE 160840

1. ITALIAN DEL HAS RESPONDED TO UK REQUEST FOR
ADDITIONAL DETAILS REGARDING CHARACTERISTICS OF MACHINE
TOOLS AS FOLLOWS:

A. THE POSITIONING ACCURACY OF THE MACHINE AXES FOR
BOTH MACHINES IS PLUS/MINUS 0.025MM PLUS 0.02/1000MM.
0.025 IS PROPER ACCURACY OF THE MACHINE INDEPENDENTLY OF
THE TRAVEL AND 0.020/1000 IS INCREMENT FOR EACH METER
TRAVEL.

B. THE ACCURACY OF RADIAL AND AXIAL MOTIONS MEASURED AT
THE SPINDLE AXIS IN ONE REVOLUTION OF THE SPINDLE FOR
BOTH MACHINES IS:

RADIAL MOTION TIR - 0.015MM

AXIAL MOTION TIR - 0.01MM

CONFIDENTIAL

CONFIDENTIAL

PAGE 02 PARIS 21874 281537Z

C. BOTH MACHINES HAVE NO MORE THAN THREE SIMULTANEOUS
COORDINATED MOTIONS BECAUSE OF THE CORRESPONDENT NUMBER
OF 3 SCR FEEDING DEVICES. BOTH MACHINES CONFIRM TO
TECHNICAL NOTES 1 AND 2 AS FOLLOWS:

BOTH MACHINES HAVE ONE ONLY WORKING SPINDLE.

THE SPINDLE IS COMPOSED OF TWO ELEMENTS ROTATING INTEGRAL WITH EACH OTHER. OF THESE TWO ELEMENTS, ONE SPINDLE IS FIXED AXIALLY AND ONE (BORING SPINDLE) SLIDES AXIALLY. IT IS NOT POSSIBLE, IN ANY CASE, TO USE MORE THAN ONE OF THESE TWO ELEMENTS AT A TIME.

B. EACH MACHINE CAN WORK ON TWO MACHINING STATION, IE FLOOR PLATES AND ROTOTRAVERSING TABLE. THE ROTOTRAVERSING TABLE HAS TWO AXES CONTROLLED BY NC AND MOVING SIMULTANEOUSLY WITH THOSE OF THE MACHINE, UP TO A MAXIMUM OF THREE AT A TIME. TRAVEL AXIS R IS PARALLEL WITH W AXIS OF RAM OR MOVABLE HEADSTOCK AND Z AXIS OF BORING SPINDLE. TRAVEL AXES CAN THEREFORE ONLY BE CONTROLLED AT COST OF W OR Z AXIS.

ROTATION AXIS B IS CONTROLLED BY A POINT TO POINT SYSTEM TO SET THE TABLE AND THE WORKPEICE ON IT IN FOUR DEFINITE ANGLE POSITIONS (EVERY 90 DEGREES FOR MACHINING OF STATOR FRAMES OF ELECTRICAL GENERATORS). IN CORRESPONDENCE OF THE FOUR ANGLE POSITIONS THERE ARE FOUR MECHANICAL LOCKING BOLTS FOR POSITIONING ACCURACY WHILE MACHING IS IN PROGRESS.

2. USDEL WAS WITHOUT INSTRUCTIONS ON JULY 26 SCHEDULED DATE. ITALIAN DEL GRANTED ONE WEEK EXTENSION TO AUG 2.
CONFIDENTIAL

CONFIDENTIAL

PAGE 03 PARIS 21874 281537Z

3. ACTION REQUESTED: US VIEWS BY AUG 2.
SALZMAN

CONFIDENTIAL

NNN

Message Attributes

Automatic Decaptioning: X
Capture Date: 01-Jan-1994 12:00:00 am
Channel Indicators: n/a
Current Classification: UNCLASSIFIED
Concepts: ELECTRONIC EQUIPMENT, TOOLS, COMPUTERS
Control Number: n/a
Copy: SINGLE
Sent Date: 28-Jul-1977 12:00:00 am
Decaption Date: 01-Jan-1960 12:00:00 am
Decaption Note:
Disposition Action: RELEASED
Disposition Approved on Date:
Disposition Case Number: n/a
Disposition Comment: 25 YEAR REVIEW
Disposition Date: 22 May 2009
Disposition Event:
Disposition History: n/a
Disposition Reason:
Disposition Remarks:
Document Number: 1977PARIS21874
Document Source: CORE
Document Unique ID: 00
Drafter: n/a
Enclosure: n/a
Executive Order: X1
Errors: N/A
Expiration:
Film Number: D770271-0758
Format: TEL
From: PARIS USOECD
Handling Restrictions: n/a
Image Path:
ISecure: 1
Legacy Key: link1977/newtext/t1977079/aaaaahkc.tel
Line Count: 97
Litigation Code IDs:
Litigation Codes:
Litigation History:
Locator: TEXT ON-LINE, ON MICROFILM
Message ID: 7aceb370-c288-dd11-92da-001cc4696bcc
Office: ACTION EB
Original Classification: CONFIDENTIAL
Original Handling Restrictions: n/a
Original Previous Classification: n/a
Original Previous Handling Restrictions: n/a
Page Count: 2
Previous Channel Indicators: n/a
Previous Classification: CONFIDENTIAL
Previous Handling Restrictions: n/a
Reference: 77 STATE 160840
Retention: 0
Review Action: RELEASED, APPROVED
Review Content Flags:
Review Date: 03-Mar-2005 12:00:00 am
Review Event:
Review Exemptions: n/a
Review Media Identifier:
Review Release Date: n/a
Review Release Event: n/a
Review Transfer Date:
Review Withdrawn Fields: n/a
SAS ID: 1959402
Secure: OPEN
Status: NATIVE
Subject: ITALIAN MACHINE TOOLS TO USSR - IL 1091
TAGS: ESTC, IT, UR, COCOM
To: STATE
Type: TE
vdkgvwkey: odbc://SAS/SAS.dbo.SAS_Docs/7aceb370-c288-dd11-92da-001cc4696bcc
Review Markings:
Margaret P. Grafeld
Declassified/Released
US Department of State
EO Systematic Review
22 May 2009
Markings: Margaret P. Grafeld Declassified/Released US Department of State EO Systematic Review 22 May 2009